

Work Order ID 126083

126083

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October-27-14 1:36:58 PM

Item ID: D3282-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Float Web (206L 407)

Start Date: 10/27/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 10/31/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3282	D

100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut to length as per Dwg D3282.
2- inspect for surface damage as per QSI0018
3- Debur

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA579 & Dwg D3282
2-Debur

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

DAS

20

9-89

DAS

44

9-89

DAS

20

9-89

15-03-13

15/03/14

15-03-13

DQA:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: <u>126083</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☒ Crosstube ☐ Machining ☐ Small Fab ☐ Thermoforming ☐ Finishing ☐ Large Fab ☐ Composite ☐ Water Jet ☐ Engineering ☐ Prod. Eng. Coord. ☐ Quality ☐ Rec/Store/Packaging ☐ Other ☐ Supplier ☐			
Part No. <u>D3282-041</u>						
NCR No. <u>15-4743</u>						

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				while pulling stock		Scrap + destroy			
Doc/Data				Found 1 D2792-130		QTY: 1 D2792-130			
Equip/Tooling				with bad twist		B112219			
Handling/Pre						Replace			
Material	15-2-25	100	①				15-2-25	15-2-25	15-02-25
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☒ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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126083

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Item ID: D3282-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Float Web (206L/407)
 Start Date: 10/27/14 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 10/31/14 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160	Skidtubes					10		15-4-6	
Skidtubes	Memo	0.00							
Skidtubes	1-Install doublers as per Dwg D3282.								
170		0.00							
170	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
180		0.00							
180	Identify as per dwg & Stock Location: <u>L6002</u>	0.00							
Packaging	Memo	0.00							
Packaging									

DAS
03
9-89

(10)

15-4-7

10 15-4-6

Work Order ID 126083***126083***

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Item ID: D3282-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Float Web (206L/407)
Start Date: 10/27/14 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 10/31/14 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

ML5 1504-08

PS. 4-7

Picklist Print

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Page 1

Work Order ID: 126083

126083

Parent Item: D3282-041

D3282-041

Parent Item Name: Float Web (206L/407)

Start Date: 10/27/14

Required Date: 10/31/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:B05.09.23Procedure changeKJ/JLM
remove LPS as per dwg revD DD verf:JLM

IPP REV:C 11.09.20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2792-130		Manufactured	No			100	Each	40.0000	1	10			
D2792-130													
EXTRUSION													

Location Loc Qty Loc Code

HALL 40
112219 40

D3283-1		Manufactured	No			160	Each	47.0000	2				
D3283-1													
Doubler													

Location Loc Qty Loc Code

LG 40
119564 40
ST256 7
92179 7

MS20470AD4-7		Purchased	No			160	Each	3,096.000	57				
MS20470AD4-7													
Rivet, Universal Head													

Location Loc Qty Loc Code

ST310 3096
123525 1257
124231 539
m128228 1300

15-2-25

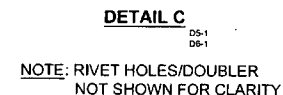
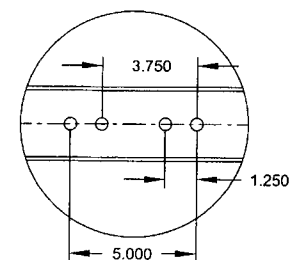
11

15-4-6

17
3

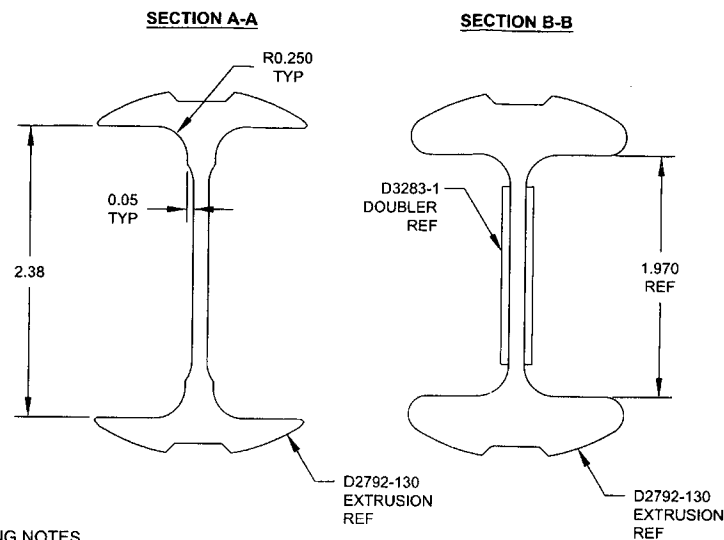
15-4-6

572



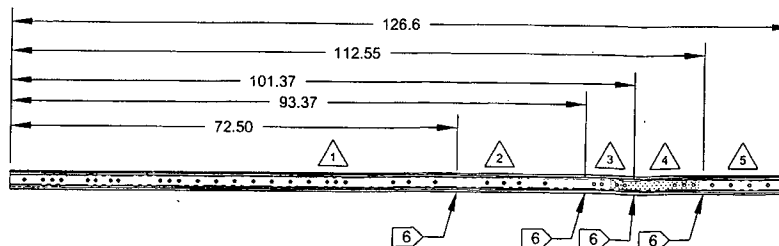
RELEASED
2011-09-12

- | | | | |
|------------|---|---|--------------|
| D | ADD ADDITIONAL HOLE (ZN D6-1); REMOVE LPS-3 (ZN C3-1) | SC | 11.05.05 |
| C | REMOVE D3390-1, NOW MACHINED | CP | 05.08.09 |
| B | MOVE HOLES, ADD D3390-1 DOUBLERS | CP | 05.03.16 |
| A | NEW ISSUE | CP | 04.05.05 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | CP | DART AEROSPACE USA, INC
PORT HADLOCK, WA | |
| DRAWN | SC | | |
| CHECKED | <i>QD</i> | | |
| MFG. APPR. | <i>EE</i> | | |
| APPROVED | <i>AP</i> | | |
| DE APPR. | <i>TH</i> | DRAWING NO. | REV. D |
| | | D3282 | SHEET 1 OF 2 |
| | | TITLE | SCALE |
| | | WEB | NTS |
| DATE | 11.05.05 | COPYRIGHT © 2004 BY DART AEROSPACE USA, INC
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D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,
SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	92	DRAWING NO.	REV. D
MFG. APPR.	EE	D3282	SHEET 2 OF 2
APPROVED	74	TITLE	SCALE
DE APPR.		WEB	NTS
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DART AEROSPACE LTD		Work Order:	126083
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.600	✓		SLO1	Tape
1.500	+/-0.010	1.495	✓		CNC-02	12" Vern
3.000	+/-0.010	2.995	✓		"	
6.000	+/-0.010	5.995	✓		"	
1.250	+/-0.010	1.245	✓		"	
30.000	+/-0.010	30.000	✓		SLO1	
1.500	+/-0.010	1.495	✓		CNC-02	
72.01	+/-0.030	72.000	✓		SLO1	
61.75	+/-0.030	61.750	✓		"	
57.50	+/-0.030	57.500	✓		"	
49.19	+/-0.030	49.190	✓		"	
43.94	+/-0.030	43.940	✓		"	
39.69	+/-0.030	39.690	✓		"	
26.68	+/-0.030	26.680	✓		"	
0.55	+/-0.030	0.550	✓		CNC-02	
1.970	+/-0.010	1.970	✓		"	
2.38	+/-0.030	2.375	✓		"	
0.05	+/-0.030	0.058	✓		"	

Measured by:	DAS 20	Audited by:	DAS 14	Preliminary Approval:	
Date:	15-03-13	Date:	15/03/15	Date:	

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	12.02.01	Dwg Rev updated	KJ	